

Work Order ID 84375

May-10-12 2:36:32 PM

84375

ASAP

Page 1

Item ID: D2656-13

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 10/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 12/05/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D					(6)			

100

100

Waterjet

FLOW CNC Waterjet

1010.040

FLOW WATER JET

Memo

1-Cut as per Dwg D2656 Dwg Rev: D Prog Rev: D 2-
Deburr if necessary

0.00

0.00

B12-5-15

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B12-5-15

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Scrubber

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D2656-13 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 10/05/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 24/05/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT83262-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13	0.00 0.00				6			8 12/05/16
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5-12-05-16		46			
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 11:00 FINISH TIME: 3200 F OVEN TEMPERATURE: 11:30	0.00 0.00				6X	✓		M/L 12/05/16

M 117338

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Picklist Print

May-10-12 2:36:36 PM

Page 1

Work Order ID: 84375

84375

Parent Item: D2656-13

D2656-13

Parent Item Name: Wearplate

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPI: F 02.10.25Re-formatKJ/RF
IPI Rev:G Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	79.0700	0.85	5.1	6		
M1010S20GA													
1010/1025 SHEET													

**

B12-5-15

Location

Loc Qty

Loc Code

MAT019

79.07

111410

35.9

116791

43.17

111410

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SUBJECT TO AMENDMENT

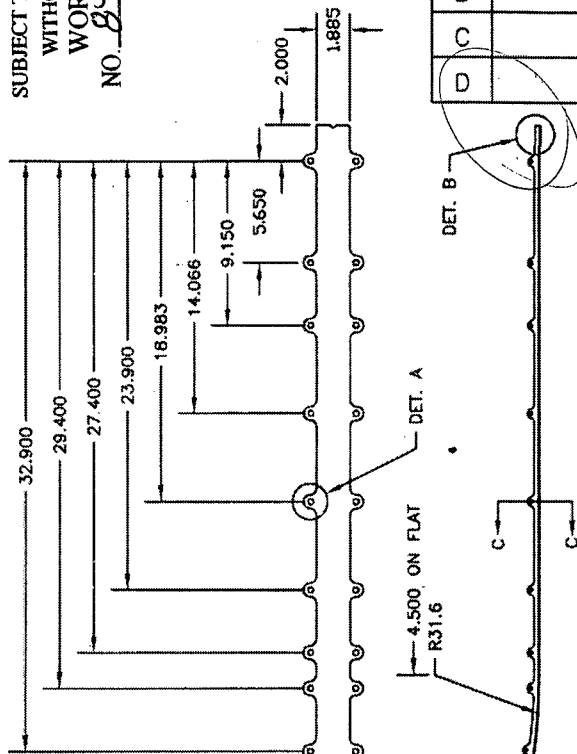
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WORK ORDER

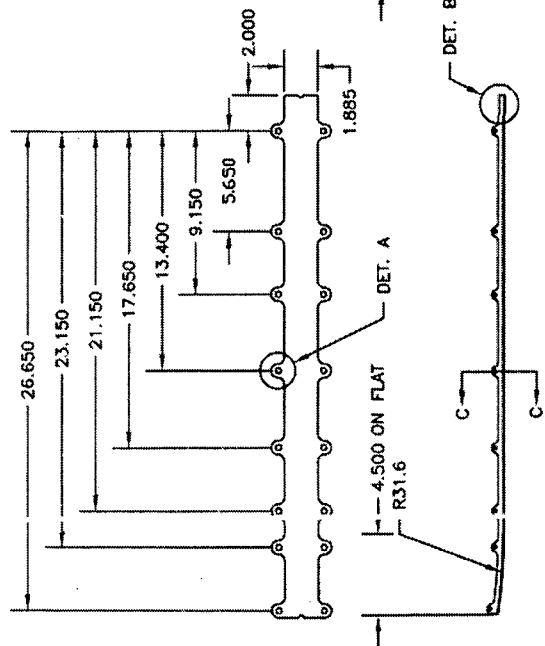
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DATE 05.08.17				TITLE WEARSHOE	SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

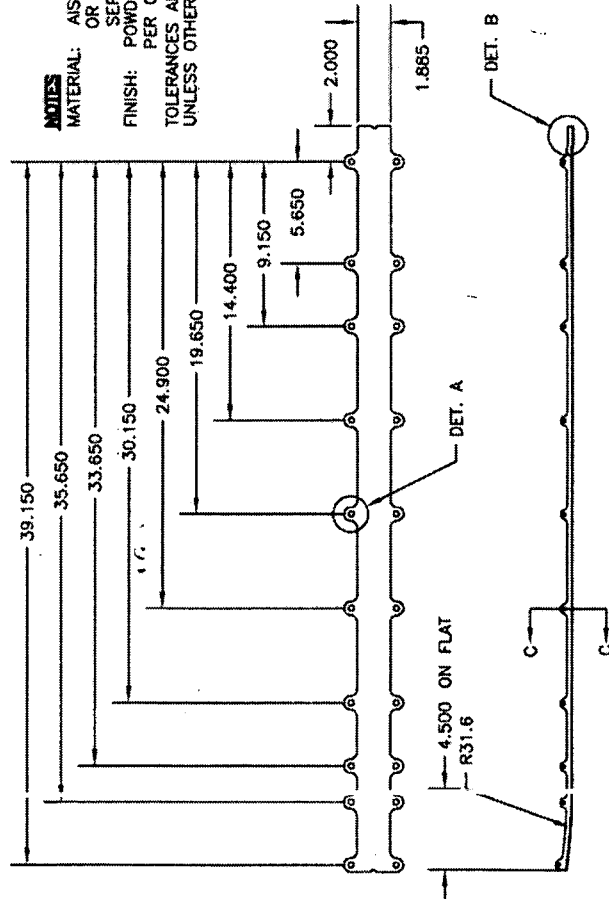
D2656-13



D2656-11



D2656-15



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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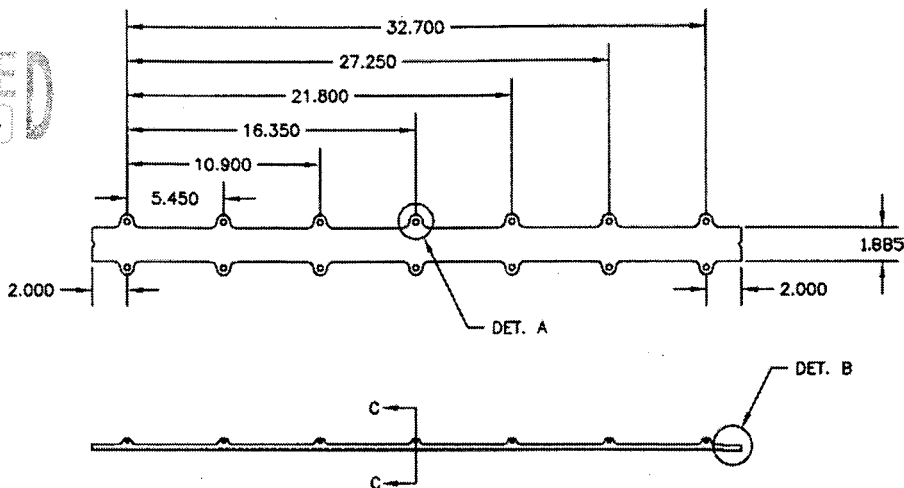
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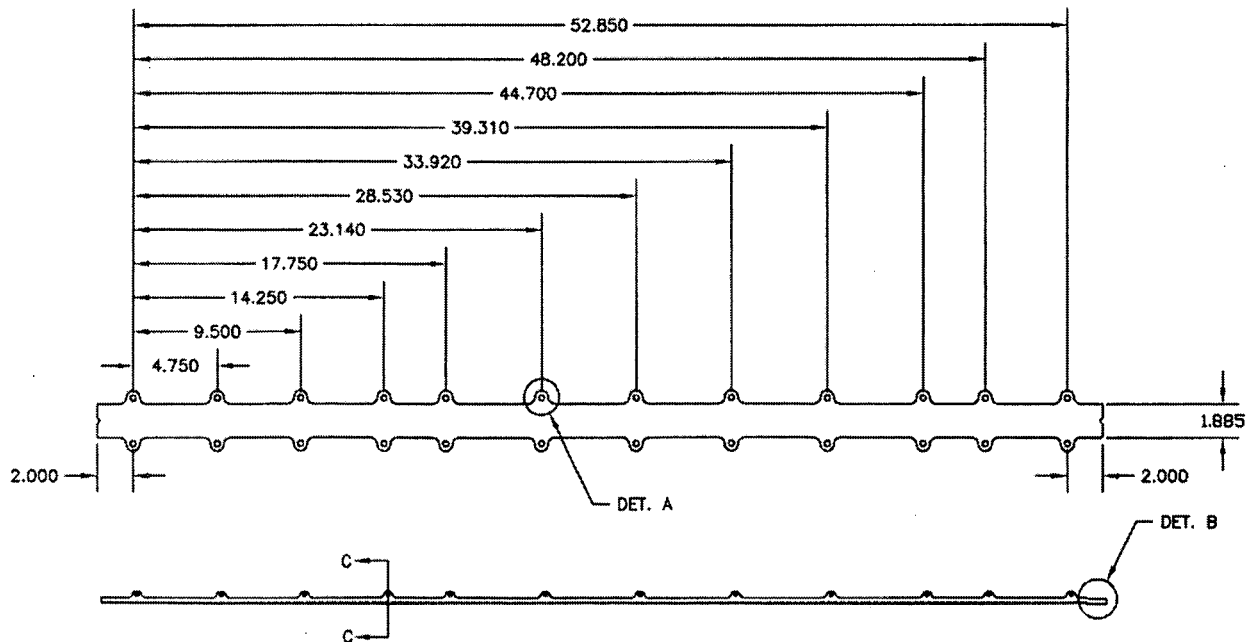
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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DS 07.06 *[Signature]*

D2656-21



D2656-23



MATERIAL

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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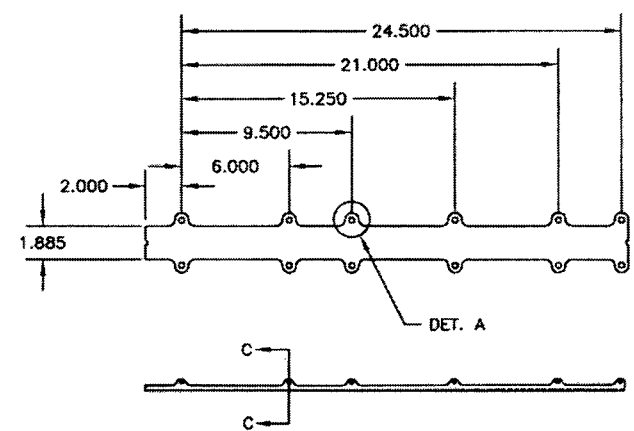
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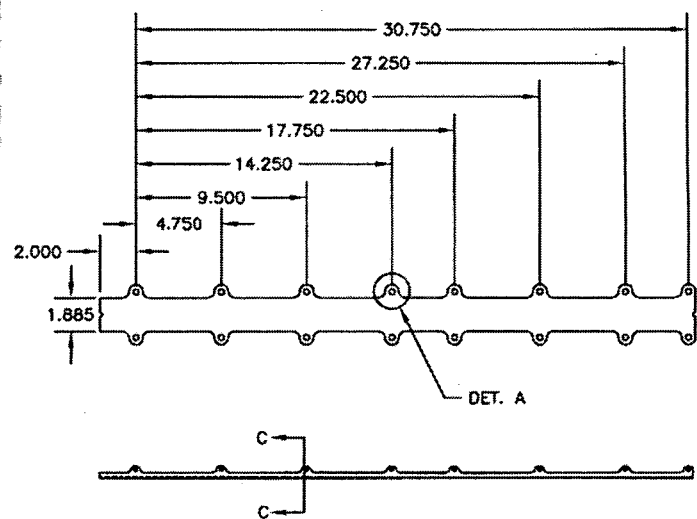


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DATE	05.08.17	DRAWING NO.	D2656	REV. D
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		SCALE	1:10	

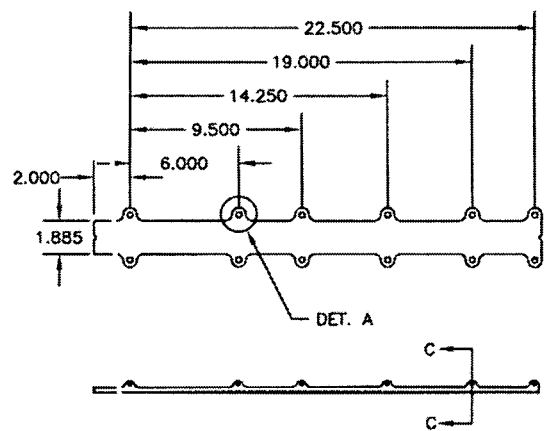
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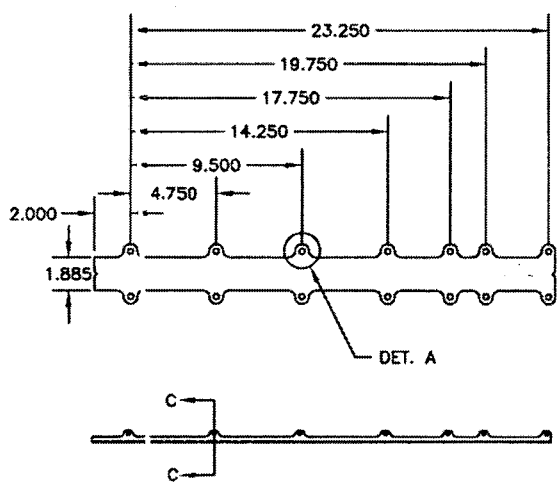
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D2656-31



D2656-35



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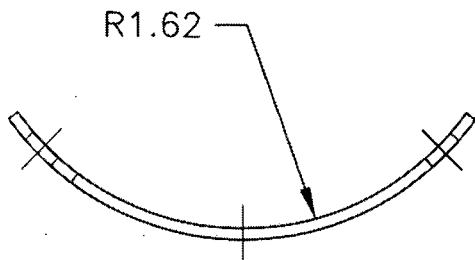
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WCSHO



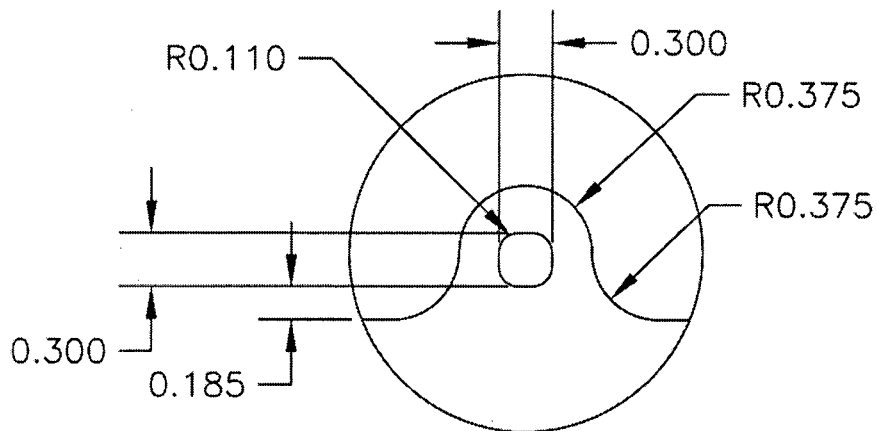
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DATE	TITLE		SCALE
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SECTION C-C

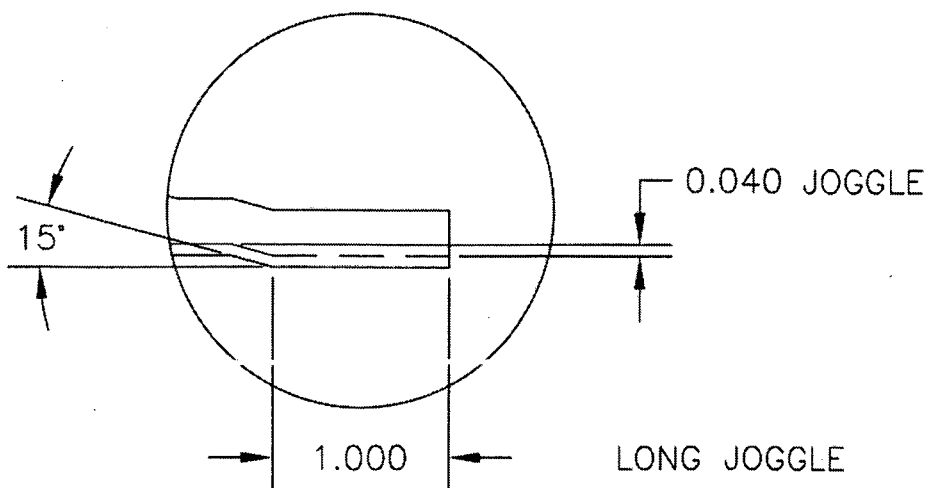


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DETAIL A



DETAIL B



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